

Date: Friday, 04/04/2008 9:22:16 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	38404		
Estimate Number :	11143		
P.O. Number :		Part Number :	D32073
This Issue :	04/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3207 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	28640	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	15/04/2008
Written By :		Qty:	10
Checked & Approved By :	JLD 08-04-4	Um:	Each
Comment :	Est A 04.06.09 New issue KJ/RF Est Rev:B Now on Waterjet 06-09-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



2



Comment: Qty.: 0.1603 sf(s)/Unit Total : 1.6034 sf(s)
 6061-T6 .125 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.125" thick
 (M6061T6S.125)
 Identify for D3207-3
 Batch: 106634 B 8-4-7

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3207
 Dwg Rev: A
 Prog Rev: A

B 8-4-7



2-Deburr if necessary

B 8-4-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-4-7

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

8 08/04/07 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38404

Part Number: D32073

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3207

SB 08/04/16

(11)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-04-16 (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-18

(11)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M106442

m-l 08/04/16

(11X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08-04-22

(X11)

Min
04/2008
S.0 07.26
#1 23.3
#2 3404
#3 3073
#4

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 243

AS 08/04/22 (X11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

Job Completion



mf 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

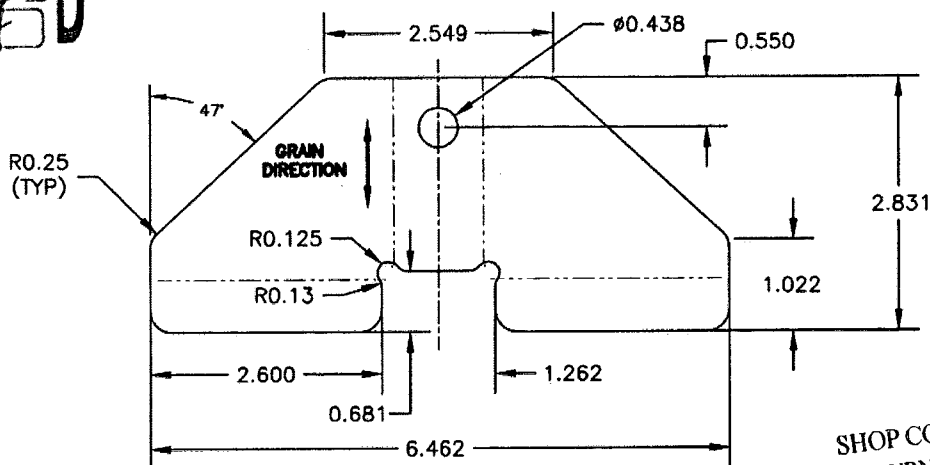
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



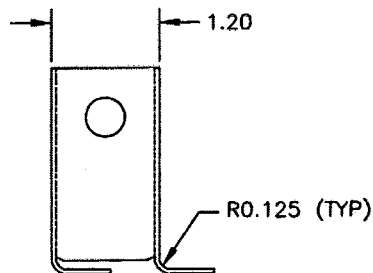
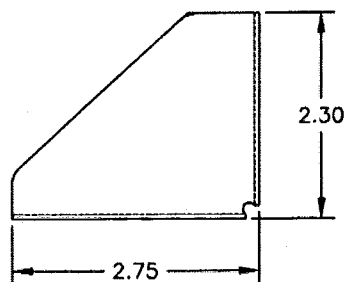
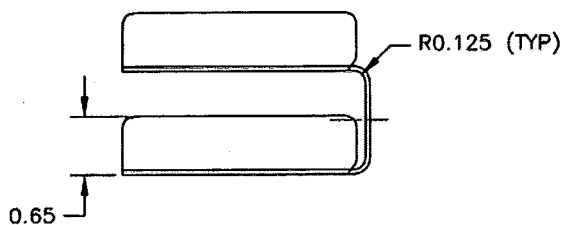
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN

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WORK ORDER
NO. 38404



D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE

D3107-1/-2 BRACKET

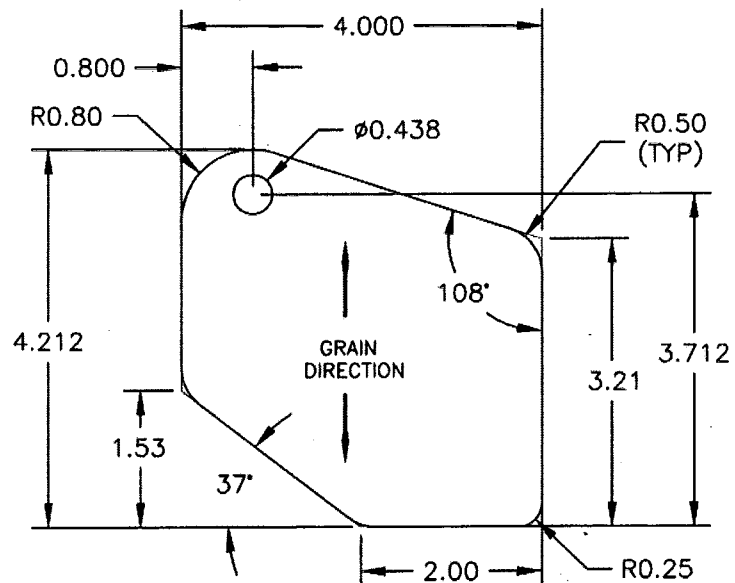
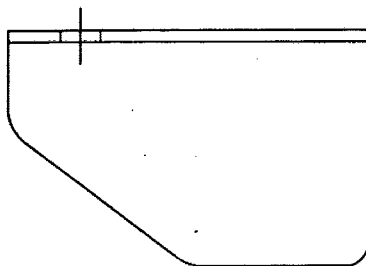
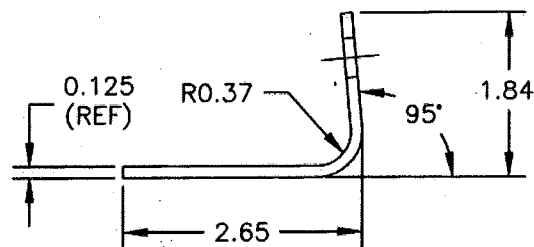
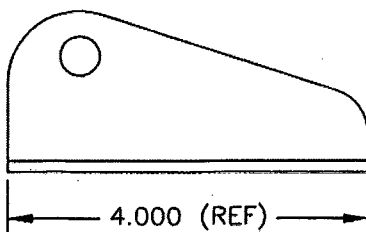
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED
04.04.05**D3207-3 FLAT PATTERN****D3207-3 BEND DETAIL****D3207-3 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010.
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE INCHES

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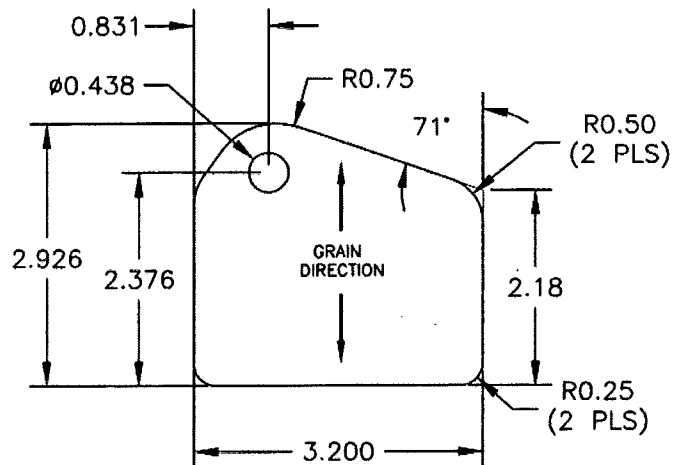
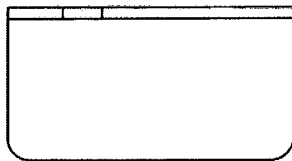
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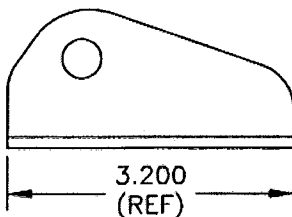


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CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

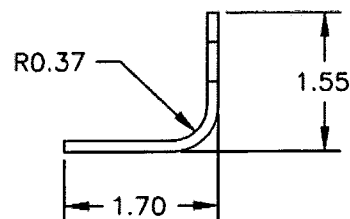
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04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL



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WORK ORDER
NO. 88404

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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